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D2534

Job Sheet 216118



Part No: D2534

Job Qty: ~~16~~ pcs

Part Name: Lock Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/30/20

Job Tracking No:

Due Date: 1/15/21

Created By: Jennifer Renwick

Type: Stock

Description: SIOP

Note: DWG REV D IPP Rev:A New Issue 05-11-07 JLM IPP Rev:B Now on Waterjet 06-06-20 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
100	Waterjet - Flow - 1	16 pcs	1/15/21	0.17	0.67		Waterjet - Flow	α 20/12/11
110	QC 2	16 pcs	1/15/21	0.00	0.00		QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	α 20/12/11
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	
							Plex 11/30/20 9:19 AM Dart.Renwick.Jenn	

Plex 11/30/20 9:19 AM Dart.Renwick.Jennife

					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
140	QC 21 - SA	16 pcs	1/15/21	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 9	
					QC 21 - SA - 77	
					QC 21 - SA - 28	

Part Op **100** - 1-Cut as per Dwg D2534
 Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB)
120 - (QC8- Inspect parts - second check)
130 - Identify as per dwg & Stock Location: WA001-2. *****STOCK IN LARGE FAB*****
140 - (QC21- Final Inspection - Work Order Release)

DAS
 77
 9-89
 DEC 16 2020

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	.6832 sf (.0427 ea)	100-Waterjet - Flow - 1	5242860

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S11GA	1	35	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lock Plate	0.447inches	+ 0.006 - 0.001	0.453 0.446	
2	Lock Plate	0.500inches	± 0.010	0.510 0.490	
3	Lock Plate	0.173inches	± 0.010	0.183 0.163	
4	Lock Plate	0.096inches	± 0.010	0.106 0.086	
5	Lock Plate	0.125inches	± 0.010	0.135 0.115	
7	Lock Plate	0.200inches	± 0.010	0.210 0.190	
8	Lock Plate	0.125inches	± 0.010	0.135 0.115	

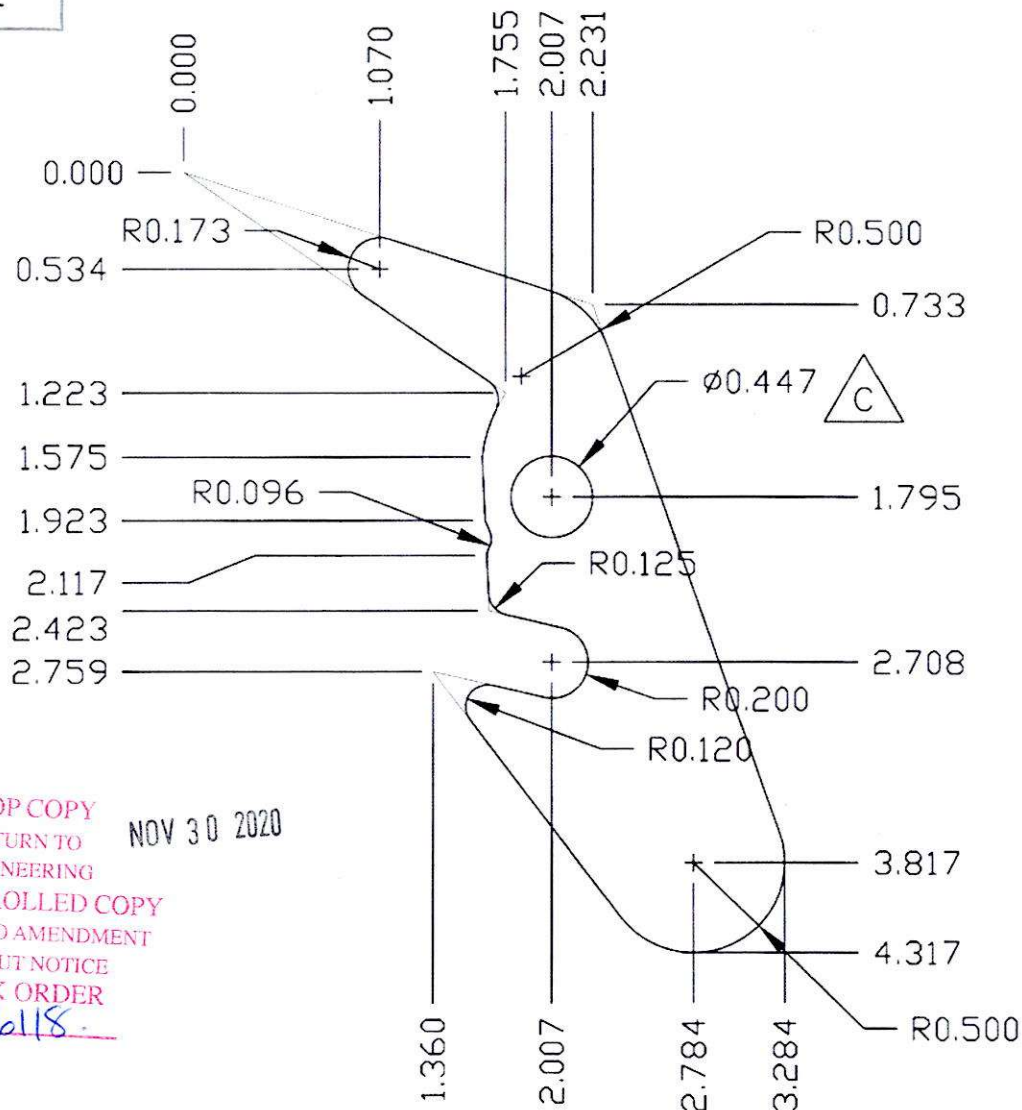
Plex 11/30/20 9:19 AM Dart.Renwick.Jennifer



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH	DRAWING NO. D2534	REV. D SHEET 1 OF 1
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	TITLE LOCK PLATE	SCALE 1:1
DATE 04.12.14			
C	96.07.26	HOLE WAS 0.328	
D	04.12.14	UPDATE NOTES	

RELEASED

04.12.16 *[Signature]*



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 216118
NOV 30 2020

D2534 LOCK PLATE

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					



Container No: S320469



Part: D2534

Job No: 216118

Serial No/Batch: S320469

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 12/11/20